

Date: Monday, 7/30/2007 1:52:22 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 33778
Estimate Number : 10495
P.O. Number : N/A
This Issue : 7/30/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 31884
Written By :
Checked & Approved By :
Comment : est rev H 07.06.12 ecn 825 EC

Drawing Name : LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW
Part Number : D2360
Drawing Number : D2360REVD,D2341REV F
Project Number : N/A
Drawing Revision : D1A F
Material : N/A
Due Date : 8/12/2007 Qty: 810 Um: Each

07.07.31
2

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6201 T Extrusion 4X4X3/8



Comment: Qty.: 1.1067 f(s)/Unit Total : 4.4268 f(s)

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion)

Batch: 13-26558/34

B 35952 X10

B 27357/35 07/12/04

10

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: 12.65" Long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2341 and Dwg D2341

SD 07.12.12

2

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 07.12.12

2

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 07/12/12

2

6.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Deburr and Tumble

SD 07.12.12

2

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Machine Or Operation:

Description:

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 07-12-12 (2)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: 07-12-12 (2x)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: M105914, m-h, 07/12/12 (2x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 07-12-12 - (2x)

11.0

D2002015

Knob



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
Knob

Handwritten: B 16177B x (4) MF

12.0

D2345

Lock Channel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Lock Channel

Handwritten: B 29144 x (2) MF

13.0

D2366

Lock Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
Inventory

Handwritten: B 31955 x (4) MF

14.0

D2367

Handle Knob



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Inventory

Handwritten: B 29146 x (2) MF

Handwritten: 07-12-12

User: Kim Johnston

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Job Number: 33778

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Quick Release

B 31924 x(4)

mf

16.0

D2373

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Spring

B 26458 x(2)

mf

17.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pip Pin Assembly

B 29379 x(2)

mf

18.0

AN526C1032R18

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

m 4523 x(2)

mf

19.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer

m 105792 x(4)

mf

20.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
Washer

m 104374 x(16)

mf

21.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Rivet, Universal Head

m 15541 x(2)

mf

22.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut

m 105558 x(6)

mf

07-12-12

Handwritten text, likely a list or index, written in cursive script. The text is arranged in columns and appears to be a detailed record or inventory.

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Job Number:



Seq. #:

Machine Or Operation:

Description:

23.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Screw m13719 x(2) mf

24.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
Screw m104156 x(4) mf

25.0

NAS679A3W

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Nut m1463 x(2) mf

07-12-12

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D2360 mf 07-12-12. (2)

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP C 07/12/12 x(2)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

7/12/12 (2)

29.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE (2) 07/12/13

Job Completion



07-12-13

| | | | |
|--|--------|--------------|-------|
| DART AEROSPACE LTD | | Work Order: | 33778 |
| Description: Litter Tie Down Bracket (Locking) | | Part Number: | D2341 |
| Inspection Dwg: D2341 | Rev: F | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 1.500 | +/-0.010 | 1.506 | / | | | |
| 1.000 | +/-0.010 | 1.005 | / | | | |
| Ø0.242 | +0.005/-0.001 | Ø.242 | / | | | |
| Ø0.191 | +0.005/-0.001 | Ø.192 | / | | | |
| R0.250 | +/-0.010 | R.250 | / | | | |
| 1.700 | +/-0.010 | 1.693 | / | | | |
| 0.750 | +/-0.010 | .755 | / | | | |
| 2.750 | +/-0.010 | 2.757 | / | | | |
| 11.000 | +/-0.005 | 11.004 | / | | | |
| 5.500 | +/-0.010 | 5.504 | / | | | |
| 1.584 | +/-0.010 | 1.588 | / | | | |
| Ø0.191 | +0.005/-0.001 | Ø.192 | / | | | |
| 2.610 | +/-0.010 | 2.615 | / | | | |
| 0.844 | +/-0.010 | .843 | / | | | |
| 1.250 | +/-0.010 | 1.255 | / | | | |
| 0.750 | +/-0.010 | .754 | / | | | |
| 12.500 | +/-0.010 | 12.504 | / | | | |
| 3.313 | +/-0.010 | 3.314 | / | | | |
| 4.250 | +/-0.010 | 4.250 | / | | | |
| 0.400 | +/-0.010 | .400 | / | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | | |
|-----------------|------------------|---------------------|-----|
| Measured by: SA | Audited by: S.F. | Prototype Approval: | N/A |
| Date: 07.12.12 | Date: 07/12/12 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------|------------|----------|
| A | 06.05.24 | New Issue P/O D2360 | KJ/JLM | |
| B | 07.07.17 | Dwg Rev. updated | KJ/JLM | FE |



| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN BW | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED CE | APPROVED HA | DRAWING NO. D2360 | REV. D SHEET 1 OF 2 |
| DATE 07.06.06 | | TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS | |
| A | 95.02.10 | NEW ISSUE | |
| B | 95.02.20 | RE-DESIGN | |
| C | 97.08.27 | ADD MS20470AD3-4 RIVET | |
| D | 07.06.06 | D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5) | |

RELEASED

07.06.07

PARTS LIST:

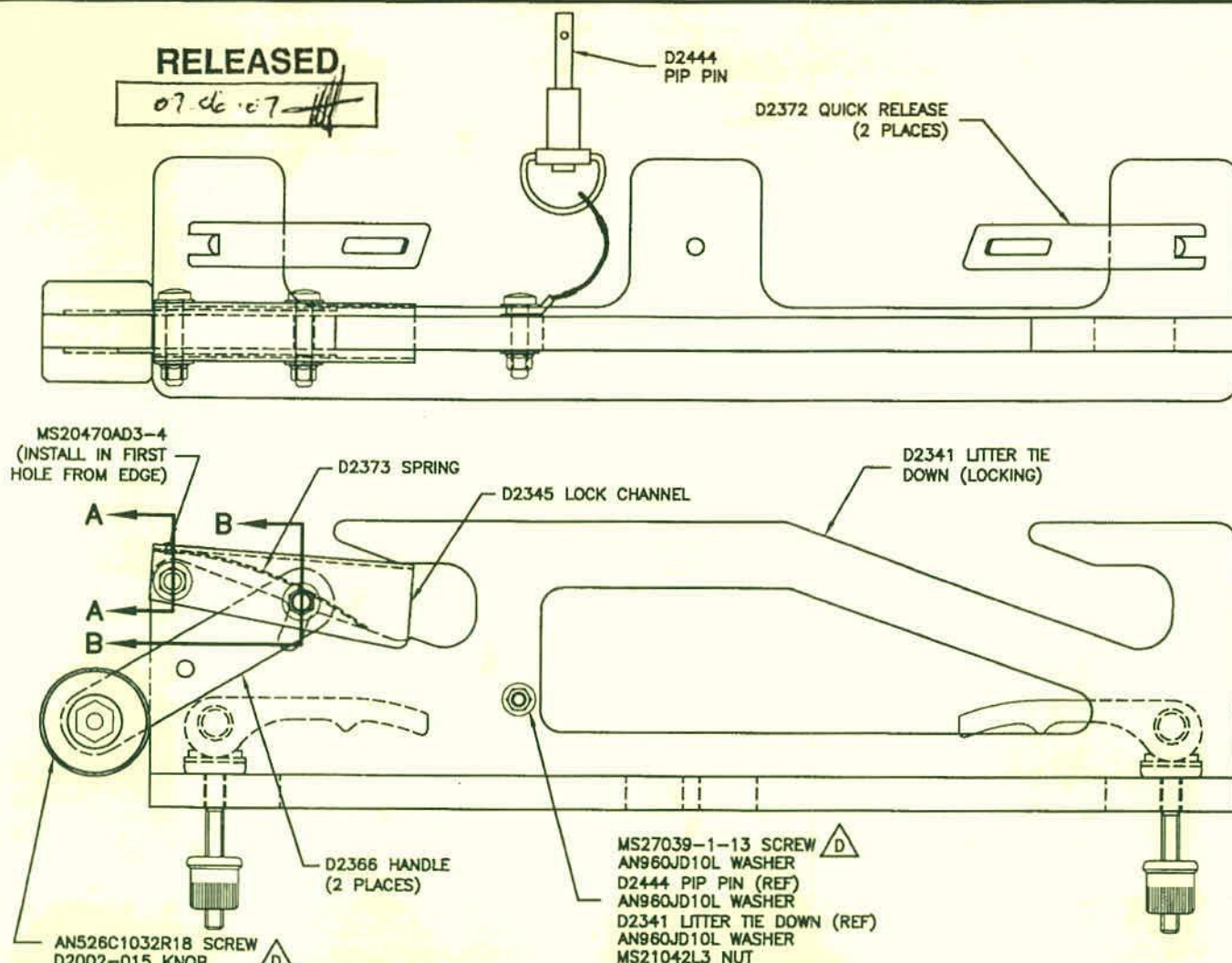
| QTY | PART NUMBER | DESCRIPTION |
|-----|---------------|------------------------------------|
| X | D2360 | LITTER TIE DOWN ASSEMBLY (LOCKING) |
| 1 | D2341 | LITTER TIE DOWN (LOCKING) |
| 1 | D2345 | LOCK CHANNEL |
| 2 | D2366 | LOCK HANDLE |
| 1 | D2367 | KNOB (DELRIN) |
| 2 | D2372 | QUICK RELEASE FASTENERS |
| 1 | D2373 | SPRING |
| 2 | D2002-015 | KNOB (DELRIN) |
| 1 | D2444 | PIP PIN |
| 1 | AN526C1032R18 | SCREW |
| 2 | AN960JD10 | WASHER |
| 8 | AN960JD10L | WASHER |
| 1 | MS20470AD3-4 | RIVET |
| 3 | MS21042L3 | NUT (OR MS21042-3) |
| 1 | MS27039-1-13 | SCREW |
| 2 | MS27039-1-15 | SCREW |
| 1 | NAS679A3W | NUT |

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NO. 33778

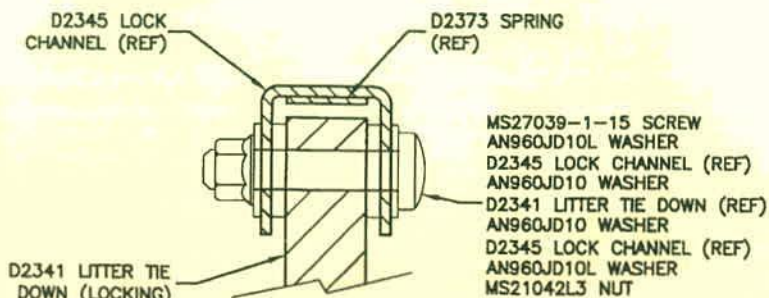
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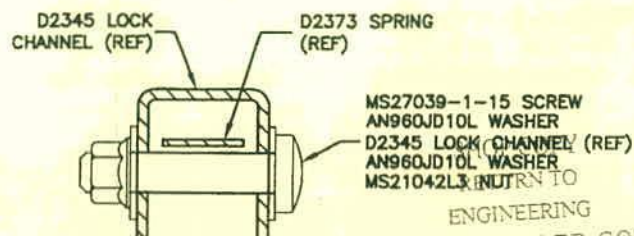
| | | | |
|-------------------------|--------------------------------|--|------------------------|
| DESIGN BW | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED CE | APPROVED [Signature] | DRAWING NO. D2360 | REV. D SHEET 2 OF 2 |
| DATE 07.06.06 | | TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS | |




D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)



SECTION A-A
(SCALE 1:1)



SECTION B-B 
(SCALE 1:1)

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